

Page 1

Tuesday, May 18	8, 2010 3:09:57 PM											
Item ID: Revision ID:	D4030-041	1	Accept				s	etup Sta				
Item Name:	Long Basket Assembly (350)							Sto	р			
Start Date: Required Date: Reference:	5/18/2010 Start Qty: 1.00 5/28/2010 Req'd Qty: 1.00			Cust Item II Customer:	D:							
Approvals:	Process Plan: MF	Date: 10-5-18	Tooling:	Da	ite:		R	un Sta				
	QC:	Date:	SPC (Y/N):	Da	ite:			Sto	p			
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
Draw Nbr	Revision Nbr											
D4030	В							_				
100 Packaging Packaging	Pick Kit Memo		0.00				/u	_140	121			
110 HandFinish Hand Finishing	Assemble as per dwg Memo		0.00 0.00	D 10-05	-21		<u>.</u>		-	-		
120 	QC5- Inspect part con	npleteness to step on W/O	16,18	.ot21			<u> </u>					

Quality Control

Memo

W/O:	rospace Ltd		WORK ORDER	CHANGES			W		
DATE	STEP	PR	OCEDURE CHANGE	OTTAINGES	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						·			<u> </u>
Part No	:	PAR #:	Fault Category:	NCR	: Yes	No DQ	4 :	_ Date: _	
	Resolution:		Disposition:	QA:	N/C C	losed:		Date:	· · · · · · · · · · · · · · · · · · ·
Resolution:			WORK ORDER NON-CONFORMANCE (NCR)			Date:			

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)				
DATE	0.750	Description of NC		Corrective Action Section B		Verification	Annual	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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Work Order ID 58778

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Page 2

Item ID:

D4030-041

5/18/2010

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Long Basket Assembly (350)

Cust Item ID:

Customer:

Draw

Number

Required Date: 5/28/2010

Req'd Qty: 1.00

Start Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date:

Stop

Sequence ID/ Work Center ID

130

Packaging

Operation Description

QC:

Identify as per dwg & Stock Location:_

Memo

Set Up/ **Run Hours**

SPC (Y/N):

0.00

Run

Start

Insp.

Packaging

140

QC

Quality Control

PM58772

Date:_____

0.00

Rev.

Draw

Date:

Plan Code

Accept Qty

Reject Qty _

Reject Number Stamp

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/25 95) MW 10-5-21

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W/O:													
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR	: Yes I	lo DQ	A :	_ Date: _				
					QA: N/C Closed: Date:								
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								,			
DATE	STEP	Description of NC	cription of NC Corrective Action				Verific	cation	Approval	Approval			
	0.2	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector			

Tuesday, May 18, 2010 3:09:56 PM

Work Order ID: 58778

D4030-041

Parent Item: Parent Item Name:

Long Basket Assembly (350)

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

per dwg revB DD 10.04.20 verified by:EC



IPP Rev:B as

Start Date: 5/18/2010

Start Qty: 1.00

Required Date: 5/28/2010

Required Qty: 1.00

Component Item ID/ Item Name D2530 Handle Weldment	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Locati	Route Seq II 100		Qty on Hand 6.0000	Qty per K	it Qty Issued	Date Status Issued
				Location	<u>n</u>	<u>L</u>	oc Qty	Loc Code			
				ST506	57736		6 1				
D2535		Manufactured	,~ ^{No} ,	- 37.	57964	100	5 Each	148.0000	2	57969	
Spring				Location	1	I	oc Oty	Loc Code			
				ST504	<u>.</u>	<u> </u>	148	Loc Code			
					56355 58331	•	48			56300	
D2537 Bushing		Manufactured	No		38331	100	100 Each	65.0000	4		a
2				Location	<u>1</u>	<u>L</u>	oc Oty	Loc Code			
				ST504			65				
					53181 57722 58429		5 20 40			57722	
D3913-041 Long Basket Base Assemby, 3		Manufactured	No			B5869	Each	0.0000		SAO	10-05-21
D3914-041		Manufactured	No			100	Each	0.0000	1		
Long Basket Lid Assembly (35	50)					B5866	55			SAD	10-05-21

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		<u>,</u>								
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	No D	QA:	Date:		
	R	esolution:	Dispositio	n:	_ QA: N/C	Closed: _		Date: _		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	R)				
DATE	STEP	Description of NC Section A	Initial	Action Description	tion B	K S	ification ection C	Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng	Dat	е		i		
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Tuesday, May 18, 2010 3:09:56 PM

Work Order ID: 58778

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Comments:

Parent Item:

IPP Rev:A new issue DD 10.03.23 verified by:EC

per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Date: 5/18/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name D3917-3

Washer

Item ID

Replacement Mfg/ Purch Manufactured

Primary Bin Item Location No

Last Location Route Seq ID 100

Unit of Measure Each

Qty on Hand 24.0000

Qty per Kit

Otv Issued Date Issued

Status

1359607

D3953-3

Gas Spring Stud, Lid

D3953-7

Spring Spacer

D3953-9 Gas Spring Washer Manufactured , No

Manufactured

Manufactured

No

No

57144 58186

Location

Location

ST101

ST096

23 100 Each

Loc Qty

100

Loc Oty

24

1

1.0000

Loc Code

9.0000

Loc Code

58186 5P

ST101

Location

53970

57978

Loc Qty 9 9 100 Each

Each

26.0000

Loc Code

(145/21 ()

Location ST101 53642 Loc Qty 26 26

Loc Code

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W/O:			WO	RK ORDER CHANG	GES		· · · · · · · · · · · · · · · · · · ·				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Ye	es No	DQA:	Date:			
	Re	solution:	Disposition	1:	QA: N/C	Close	d:	Date: _			
NCR:		•	WORK ORDE	ER NON-CONFORM	IANCE (N	CR)					
DATE STEP		Description of NC			ction B		Verification	Approval	Approvai		
		Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector		
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Work Order ID: 58778

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

Manufactured

No



IPP Rev:B as

Start Date: 5/18/2010

Start Qty: 1.00

Required Date: 5/28/2010

Page 3

Required Qty: 1.00

ŗ	er dwg revB DD	10.04.20 verified	by:EC	•					C.J.		4 600
Component Item ID/ Item Name D3953-17 Gas Spring Spacer	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure Each	Qty on Hand 2.0000	Qty per Kit	Qty Issued	Date Status Issued
				Location		Loc (<u>Oty</u>	Loc Code			
				ST101			2				
D2052 10					57143		2		_		
D3953-19 Gas Spring Bracket		Manufactured	No			100	Each	11.0000	1 2	1	
				Location		Loc (<u>Oty</u>	Loc Code			
				ST101			11				
					57607		11		_	57607	
D3953-21		Manufactured	No			100	Each	19.0000			

Gas Spring Bracket

Location Loc Qty Loc Code **ENG** 56407 6 ST102 13 57145 13 100 0.0000 Each

Spring (Basket Lid)

D3969-3

W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	NCR:	Yes N	No DQ	A:	Date:	
	Re	solution:	Disposition	1:	QA: N	I/C Clo	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR))			
DATE STEP		Description of NC		ction B	2:	Verific	ation		Approval	
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Tuesday, May 18, 2010 3:09:57 PM

Work Order ID: 58778

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as

Start Date: 5/18/2010

Required Date: 5/28/2010

Page 4

Start Qty: 1.00

Required Qty: 1.00

p	er dwg revB DD	10.04.20 verifie	d by:EC						- •	
Component Item ID/ Item Name AN3-14A Bolt	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure Each	Qty on Hand 86.0000	Qty per Kit Qty Issued	Date Status Issued
				Location		Loc	<u>Oty</u>	Loc Code		
AN3-16A		Purchased	No	ST351	114330	100	86 86 Each	69.0000	11933	
				Location		Loc	<u>Qty</u>	Loc Code		
AN5-17A		Purchased	No	ST352	113845 114523	100	69 49 20 Each	159.0000	11 3840	
Bolt				Location		Lone	O4	Los Codo		

Location Loc Oty Loc Code ST323 54 114324 54 ST339 105 113538 5 114330 100 Purchased No 100 44.0000 Each

Location

114292

ST357

Loc Qty Loc Code 44 44

Bolt

AN4-12

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Shop Packet Print

Page 4

/c/40/01 (l)

W/O:			RK ORDER CHANG	SES						
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
	Resc	olution:	Disposition):	_ QA	N/C CI	osed:		Date: _	
NCR: WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC			tion B		Verific	cation	Approval	Approval
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Work Order ID: 58778

D4030-041



Parent Item Name:

Long Basket Assembly (350)

Comments:

Parent Item:

IPP Rev:A new issue DD 10.03.23 verified by:EC

per dwg revB DD 10.04.20 verified by EC

Start Date: 5/18/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

<u> </u>	ber dwg revB DD	10.04.20 verifie	d by:EC									
Component Item ID/ Item Name AN310-4 IIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIII	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure Each	Qty on Hand 55.0000	Qty per Kit	Qty Issued	Date Issued	Status
				Locatio	<u>n</u>	Loc	: Oty	Loc Code				
				ST139			30		_			
					114341		30			, ,		
				ST314			5					
					113845		5		-			
				ST349			20		_	1		
AN310C4		D 1 1	NI.		114341	100	20			14341		
ANS 1004 		Purchased	No			100	Each	76.0000	2			
				Locatio	<u>n</u>	Loc	: Oty	Loc Code				•
				ST349			76					
					114306		76			11430%		
MS21042L3 		Purchased	No			100	Each	1,426.000	6			/ 190%
				Location	<u>n</u>	Loc	Oty	Loc Code				
				ST300			1426					
					113537		20		_			

406

1000

IPP Rev:B as

113644

114523

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W/O:			WC	RK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Ye	s No D	QA:	Date: _	
	Resc	olution:	Disposition	n:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC		ion B	Veri	fication	Approval	Approval	
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Work Order ID: 58778

D4030-041



ST309

105279

110123

Parent Item Name:

Long Basket Assembly (350)

Comments:

Parent Item:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev B as

Start Date: 5/18/2010

Required Date: 5/28/2010

Start Oty- 1 00

Required Oty: 1.00

Comments:	per dwg revB DD				IPP Re	ev:B as		5	start Qty: 1.00	·	Required Qty	y: 1.00
Component Item ID/ Item Name MS21042L5 Nut	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure Each	Qty on Hand 565.0000	Qty per Kit	Qty Issued / m// 3523	Date Issued	Status
				Location	!	Loc	<u>Oty</u>	Loc Code				
				ST300			565					
					113523		26		_			
					113537		3		_		2 -	
					114108		36		_	114168	39	
					114437 114449		100 400		_			
MS24665-151		Purchased	No		114449	100	Each	686.0000	3			
Cotter Pin		i urchased	1.0			100	Lacii	080.0000				
				Location		Loc	Oty	Loc Code				
				ST309			686			,		
					17566		686			17566		
MS24665-300		Purchased	No			100	Each	86.0000	₂ Z			1
Cotter Pin										11		Pb140/21
				Location		Loc	Oty	Loc Code				r

86

2

84

W/O:			WC	RK ORDER CHAN	GES					
DATE	STEP	PRO	PROCEDURE CHANGE By						Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
	Res	olution:	Disposition	n:	QA:	N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)	·		
DATE	STEP	Description of NC		ction B		Verific	cation	Approval	Approval	
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Tuesday, May 18, 2010 3:09:57 PM

Work Order ID: 58778

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Date: 5/18/2010

Start Qty: 1.00

Required Date: 5/28/2010

Required Oty: 1.00

Component Item ID/ Item Name

Item ID

Replacement Mfg/ Purch Purchased

Primary Bin Item Location No

Last Location Route Seq ID 100

Unit of Qty on Measure Hand Each 347.0000 Qty per Kit

Qty Issued Date Issued

Status

NAS1149F0432P

NAS1149F0563P

Washer

Location Loc Qty Loc Code ST275 347 112940 92 114405 114576

Location

18057

ST275

254 100 Each

260.0000

Washer

Location	<u>n</u>	<u>Loc</u>	<u>Oty</u>	Loc Code
ST275			60	
	108471		60	
ST298			200	
	114576		200	
		100	Each	887.0000

NAS1149F0332P

Purchased

Purchased

No

No

Each

Loc Code

WASHER

Purchased No Loc Oty 887

887

Each

182.0000

Washer

NAS1149C0432R

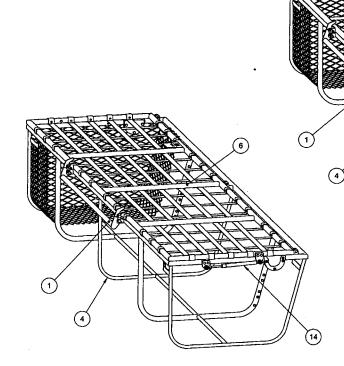
Location Loc Qty Loc Code ST297 182 114292 182

100

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W/O:			W	ORK ORDER CHAN	GES			3				
DATE	STEP	PROC	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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NCR:		W	ORK ORD	ER NON-CONFORM	MANCE	(NCR)			<u> </u>		
DATE	STEP	Description of NC			ection B	0: 0	Verific	cation	Approval	Approval		
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ITEM QTY QTY -043 DESCRIPTION LONG BASKET ASSY (350) D4030-041 X D4030-043 LONG BASKET ASSY, LIGHT LID (350) 1 1 1 D2530 HANDLE WELDMENT 2 2 D2535 SPRING 3 4 4 D2537 BUSHING 4 1 1 D3913-041 LONG BASKET BASE ASSY (350) D3914-041 LONG BASKET LID ASSY (350) 1 D3915-041 6 LIGHT LID ASSY-LONG BASKET 7 6 6 D3917-3 WASHER 2 2 D3953-3 GAS SPRING STUD, LID 9 2 2 D3953-7 GAS SPRING SPACER 10 2 2 D3953-9 GAS SPRING WASHER 11 2 2 D3953-9 11 2 2 D3953-17 12 1 1 D3953-19 13 1 1 D3953-21 GAS SPRING SPACER GAS SPRING BRACKET GAS SPRING BRACKET 14 1 1 D3969-3 SPRING 15 4 4 AN3-14A BOLT 16 2 AN3-16A BOLT 17 2 AN3-20A BOLT 18 3 3 AN4-12 19 4 2 AN5-17A BOLT (DRILLED) BOLT 20 2 AN5-21A 21 3 3 AN310-4 22 2 2 AN310C4 23 6 6 MS21042L3 BOLT NUT, CASTELLATED NUT, CASTELLATED NUT 24 4 4 MS21042L5 25 3 3 MS24665-151 26 2 2 MS24665-300 NUT COTTER PIN COTTER PIN 27 6 8 NAS1149F0432P WASHER 28 4 4 NAS1149F0563P WASHER 30 8 NAS1149F0532P WASHER 31 2 NAS1149C0432P WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

58778

С

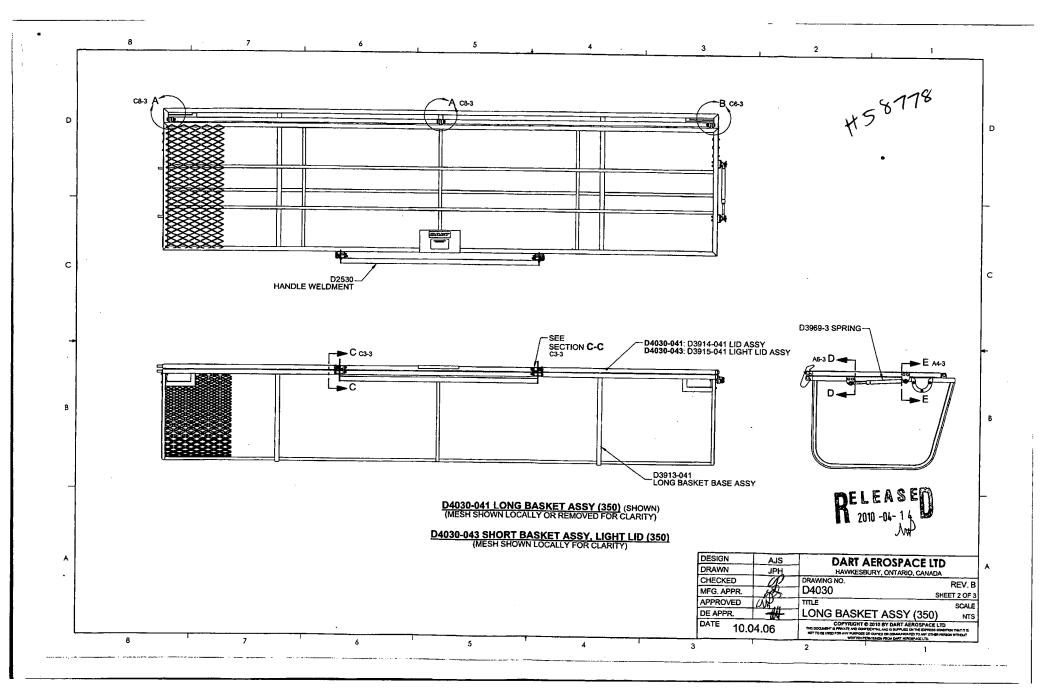
<u>D4030-043 LONG BASKET ASSY, LIGHT LID (350)</u> (MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

	В	AN5-21	A BOLT WAS	AN5-19A: BOM & (D3-3)	JPH	10.04.06
	Α	NEW IS	SUE		JPH	10.03.16
	REV.	1		DESCRIPTION	BY	DATE
	DESIG	٧	. AJS	DART AER	OSPACE	ITD
	DRAW	N	JPH	HAWKESBURY.		
	CHECK	ED	az	DRAWING NO.		REV. B
	MFG. A	PPR.	100	D4030		SHEET 1 OF 3
	APPRO		\MP	TITLE		SCALE
	DE APP	R.	_#	LONG BASKET	4SSY (35	 NTS
_	DATE	10.0	4.06	COPYRIGHT © 2010 E THIS DOCUMENT IS TRIVATE AND CONTROL IN IN THE TOTAL OR COPYED MOT TO BE USED FOR ANY PURPOSE OR COPYED MOTTER REPORTS AND MOTTER REPORTS FOR	NO IS SUPPLED ON THE EVEN	ESS CONDITION THAT IT IS
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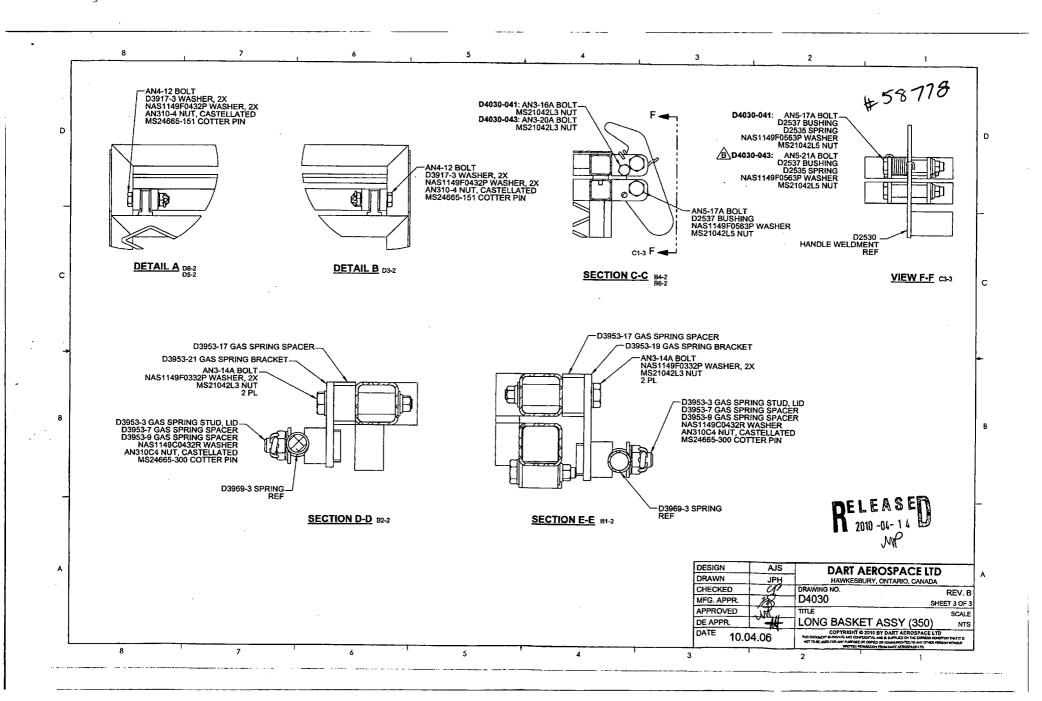
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W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA		Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	ICR:								
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No	DQA:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC	Corrective Action Section			v	erification	1 Approval	Approval
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W/O:			WO	RK ORDER CHAN	IGES					·.
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Part No	:	PAR #:	Fault Categ	ory:	NCR	: Yes N	io DQA		Date:	
		solution:								
NCR:			WORK ORDE	R NON-CONFOR	MANCE	(NCR)				
DATE	STEP Description of NC		Corrective Action		ection B		Verifica	ation	Approval	Approval
	01	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Sectio	n C	Chief Eng	QC Inspector
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Dart Aerospace Lte

	. Johnson III						
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____

Resolution:		Disposition:		QA: N/C Closed:		Date:		
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NCR)		-	
DATE	STEP	Description of NC Section A	Corrective Action Section B		В	Verification	Ammunual	Annua
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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